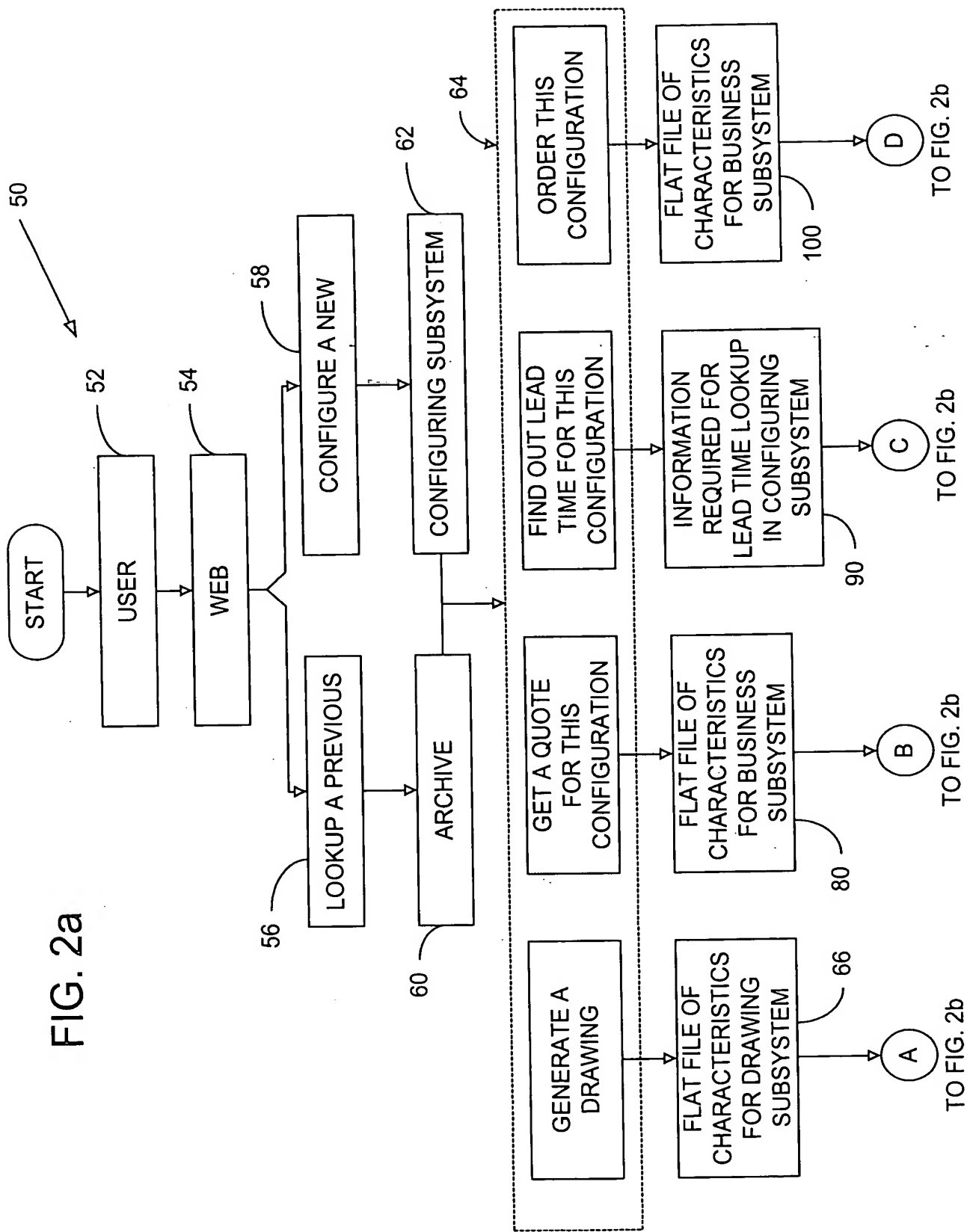


FIG. 1



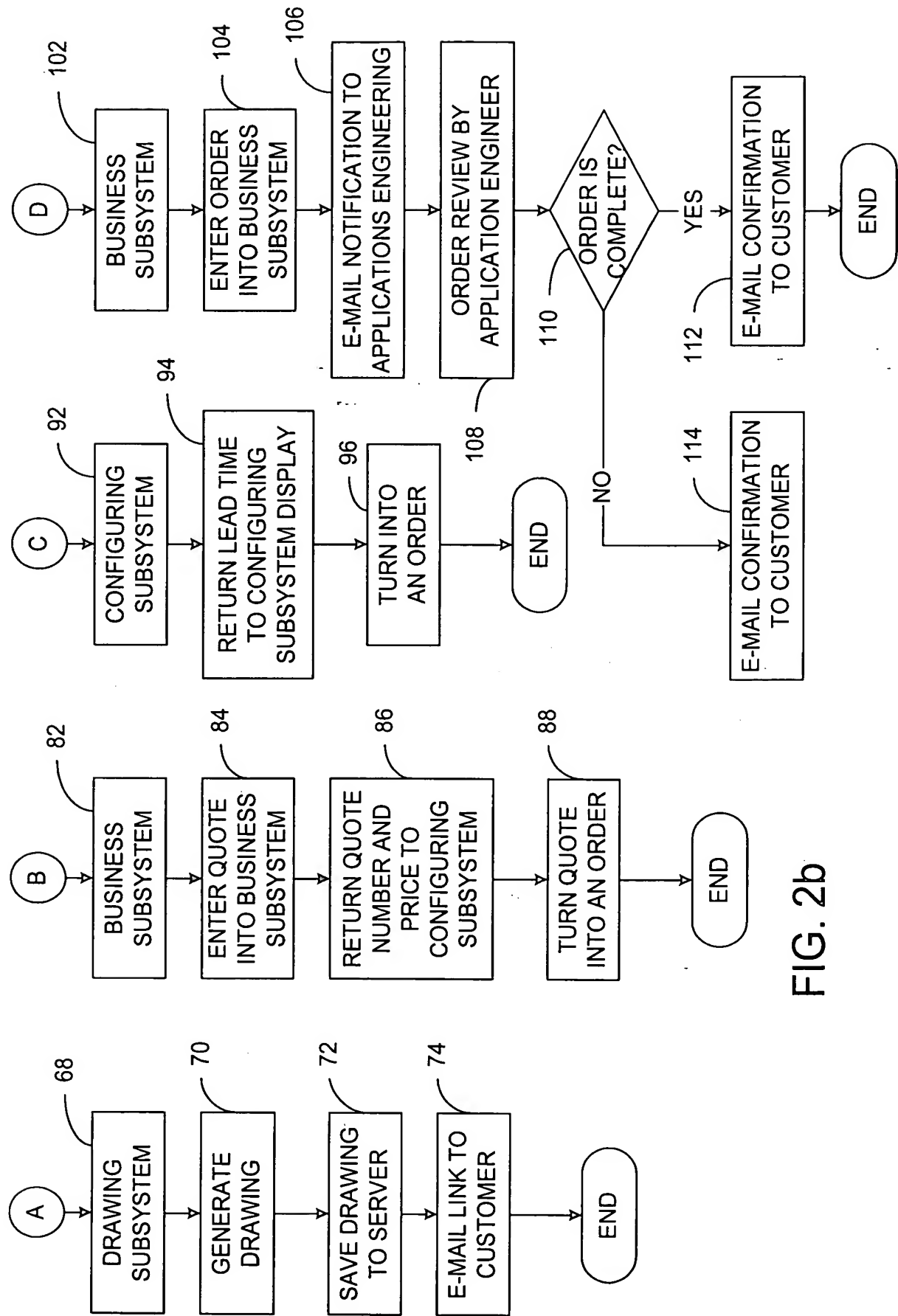


FIG. 2b

100  
↓

102

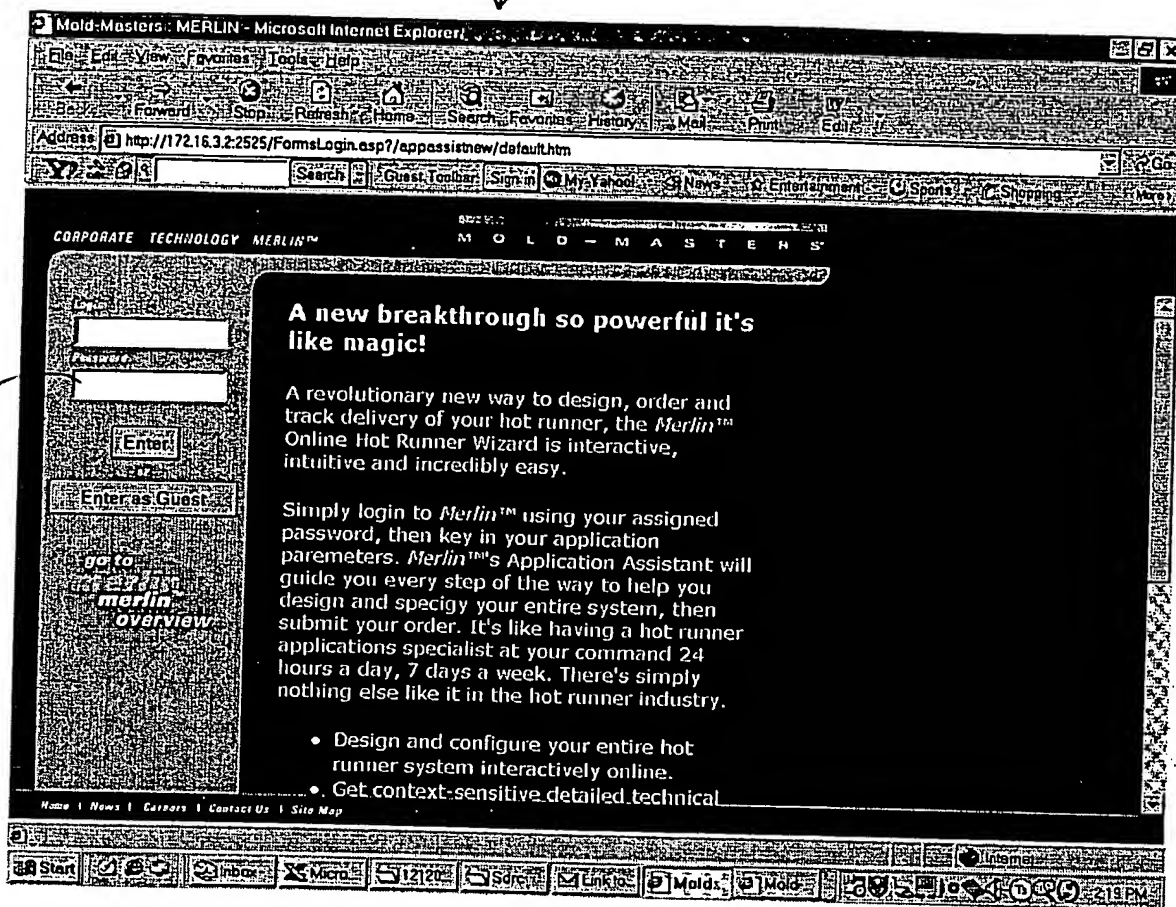
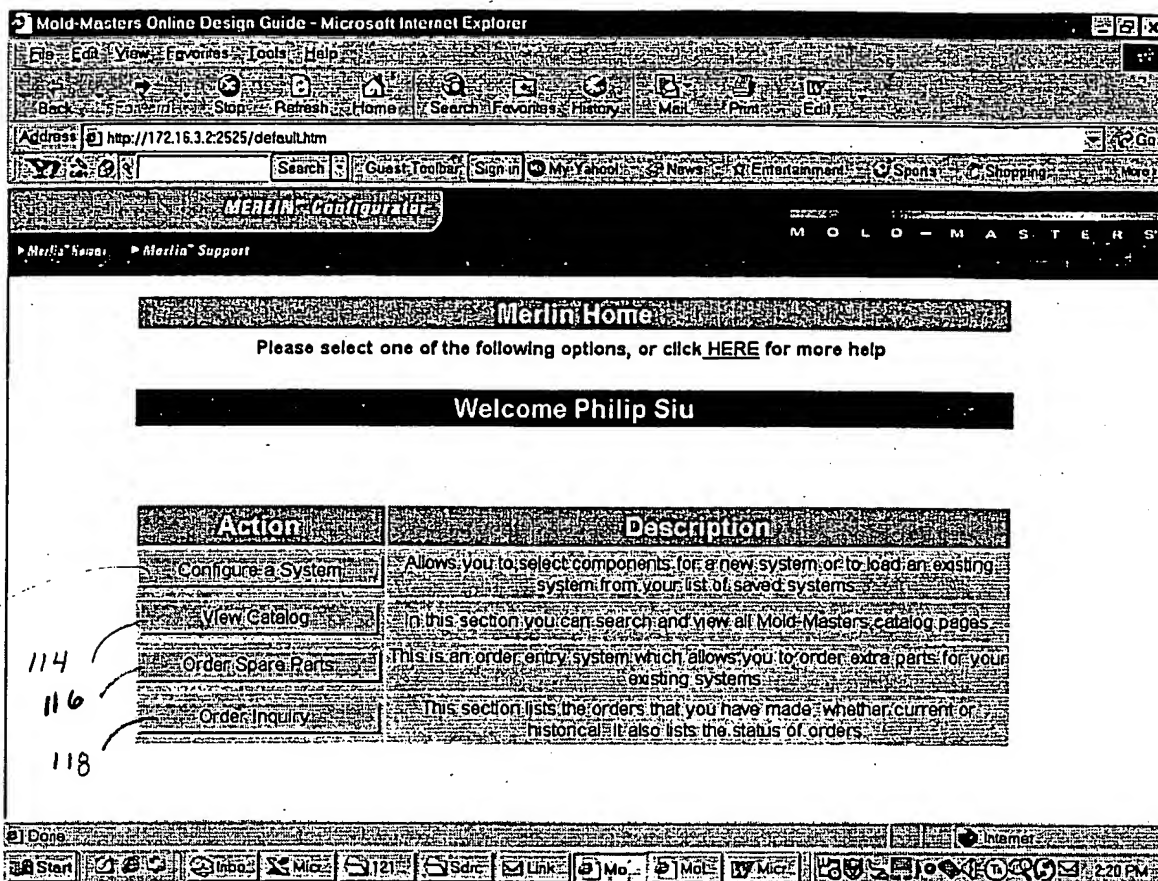


FIG. 3



120

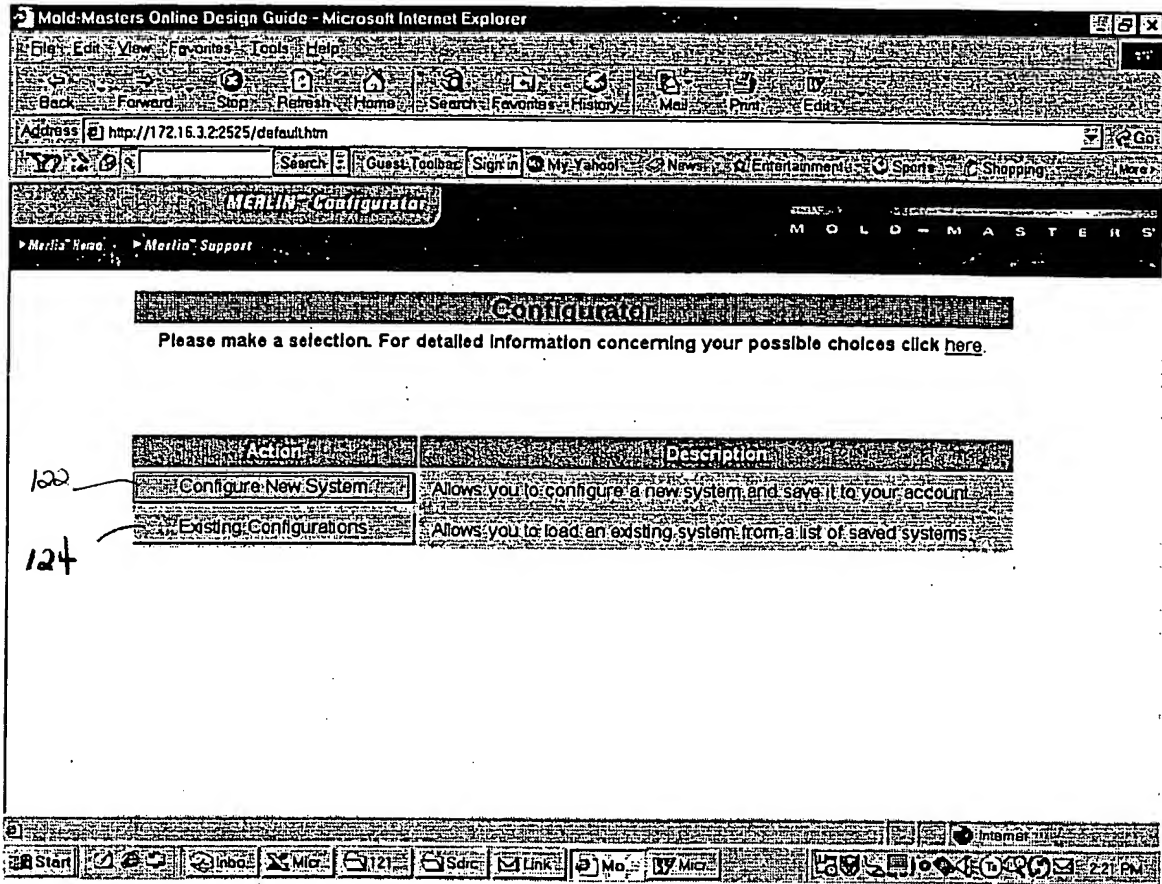


FIG. 5

130

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**MERLIN** Configurator

Merlin News Merlin Support

**Shot Weight Material Selection**

Please choose a Shot Weight, material and the filler percentage and select the GO button.  
Please click [HERE](#) for additional help.

132 134 136

Shot Weight per Nozzle	Material	Filler percentage
500 - 3500 g	Acrylonitrile Butadiene Styrene	
Go		

Done

Start Inbox Mail Links My Mail

10:54:10 AM 2/21/2000

FIG. 6.

3140

# MERLIN Configurator

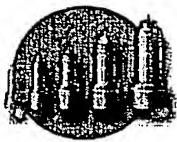
Merlin Home Merlin Support

M O L D M A S T E R S

## Product Line Selection

Please select a product line by clicking on the button below it. Click [here](#) to find out more information.

Previous Step



Dura™

142

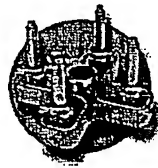
Mold Masters established Dura product line of hot runner systems.



MIM Dura-Shot®

144

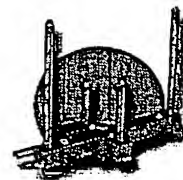
The MIM Dura-Shot® range of products is based on Mold-Masters established Dura know-how, but with the added advantages of MIM technology.



MIM Speed™

146

Specify, Design and Order your MIM Speed Hot Runner System - Online to provide the fastest delivery of the hot runner system to your specification.



Flex Dura™ System

147

The Flex Dura product line was developed specifically for the automotive and large part molding industries.



3 150

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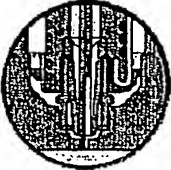
Address http://172.16.3.2:2525/default.htm

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MERLIN Configurator

Mold-Masters


Merlin Home Merlin Support



Valve Gate

152


The valve gate creates virtually no gate vestige, leaving only a barely visible ring. For this reason, valve gates offer the best solution for parts where surface quality is critical, such as medical and cosmetic products. The relatively large gate opening reduces the



Sprue Gate

154


Open style sprue gates are characterized by the sprue plug which remain on the surface of the molded part, where the cosmetic appearance of the gate is less critical. The sealing of the gate is accomplished by solidification during the cooling



Edge Gate

156

Edge gates are used to side gate onto vertical walls. The gate is sheared off as the mold opens, leaving a solid plug of plastic in the gate steel. In order to 'trap' the cold slug so that it can be re-melted during injection on the next cycle, and to prevent solidification, the gate must



Tip Gate

158

Tip gates are characterized by a small mark (gate vestige) on the molded part surface. The diameter of this mark is directly related to the gate size. The gate vestige may be above the surface of the part. Tip gates are commonly used in

Done Start Incho Mich 121 Sdc Link Mo Mic 224 PM

FIG. 8

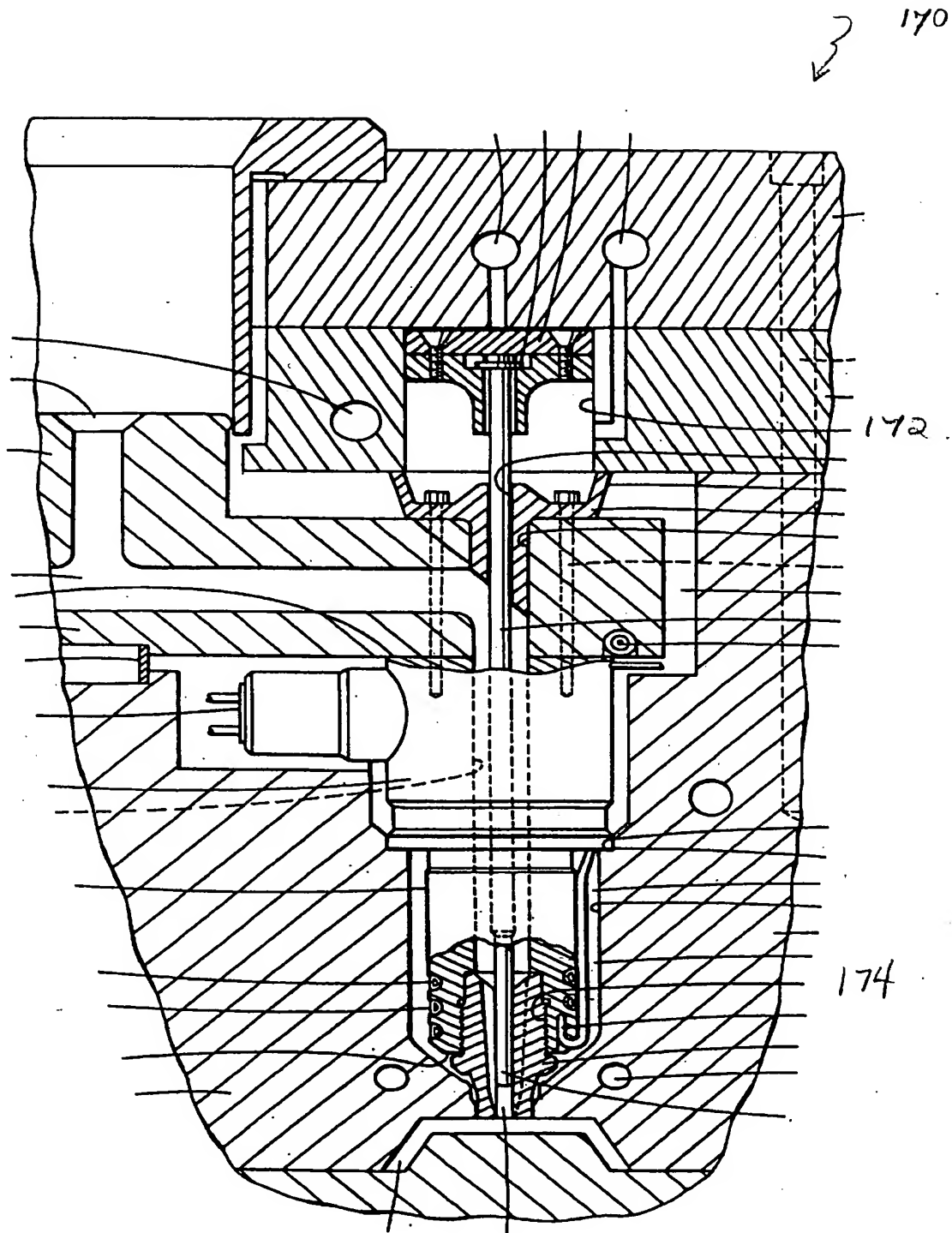


FIG. 9

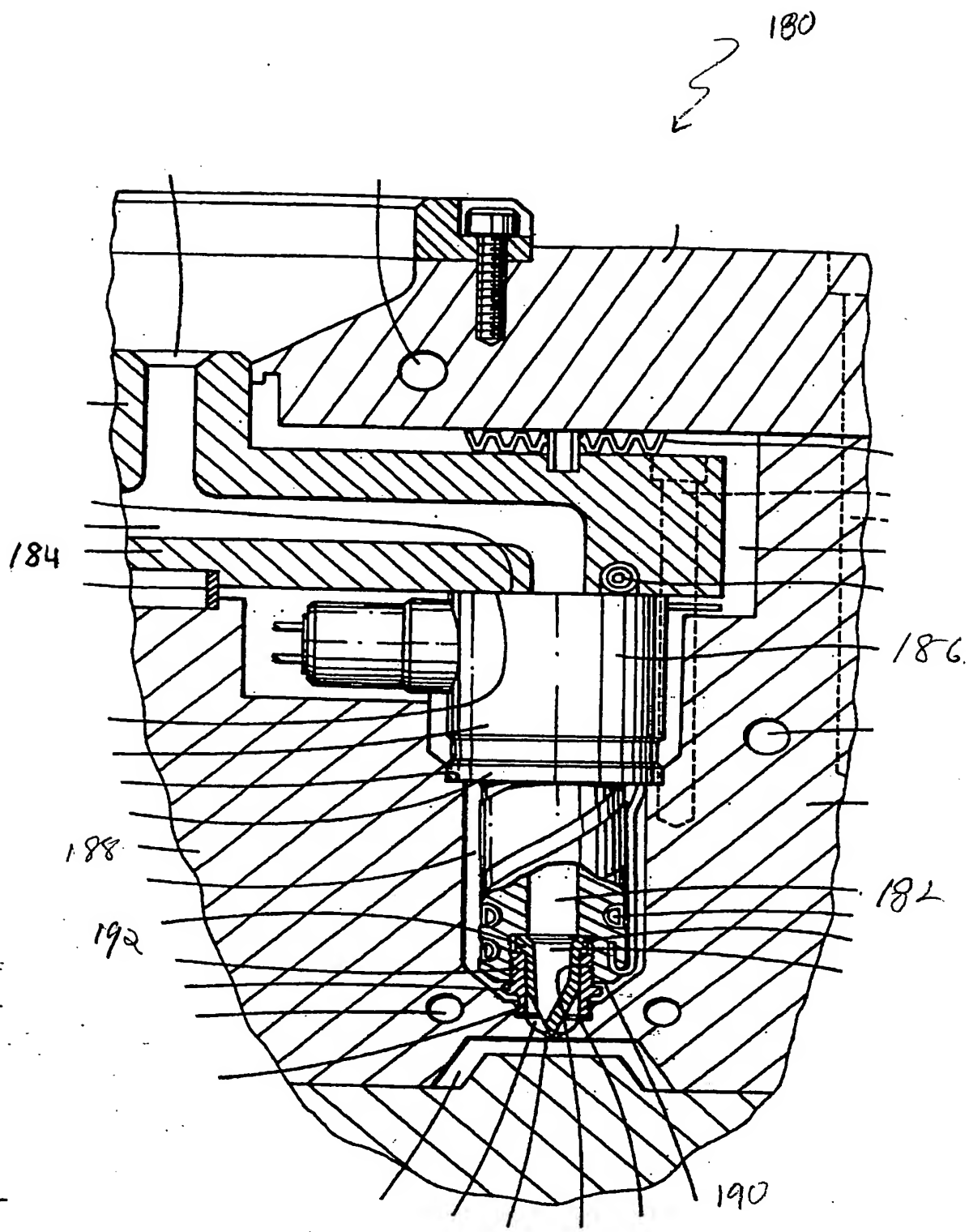


FIG. 10

200

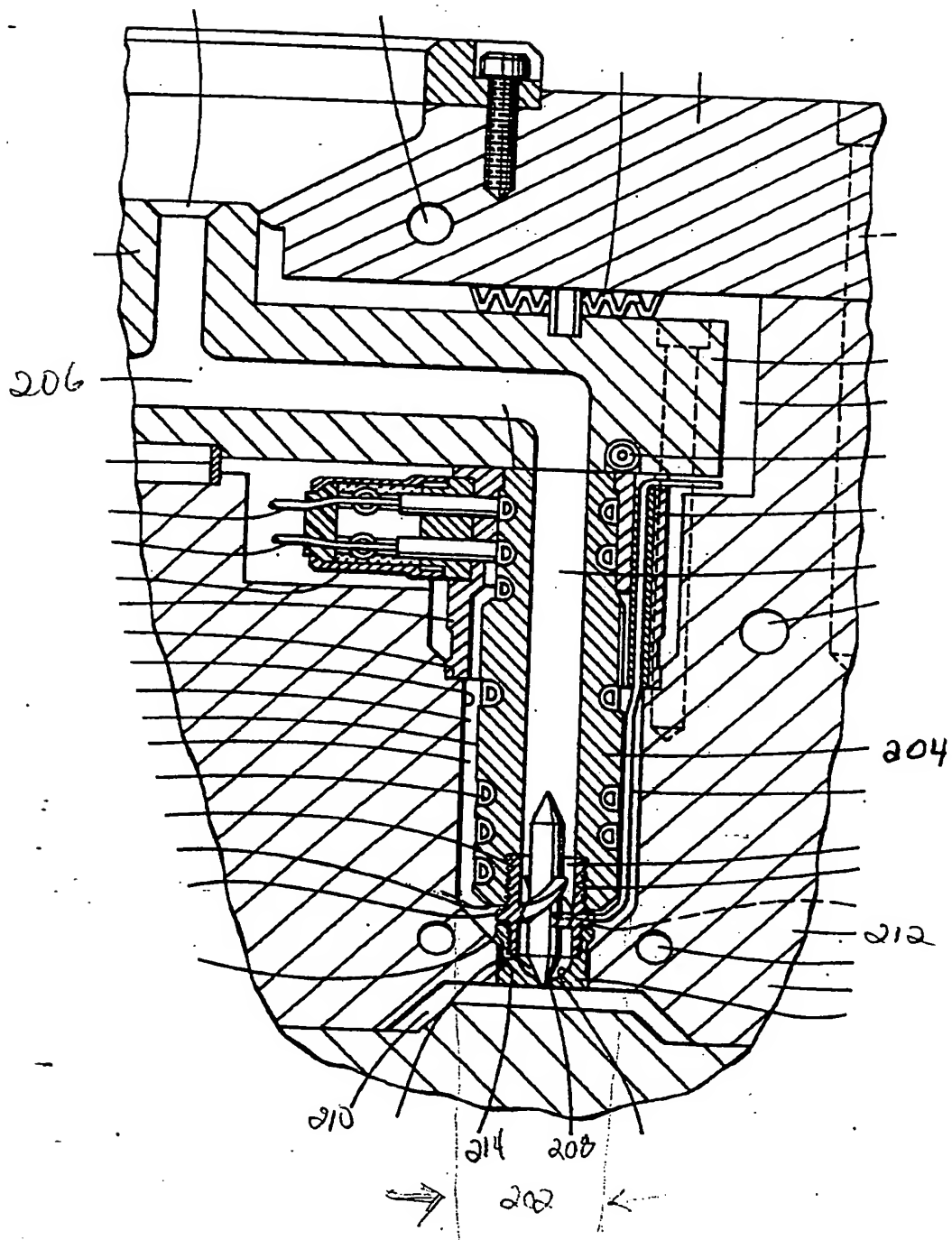


FIG. 11

220

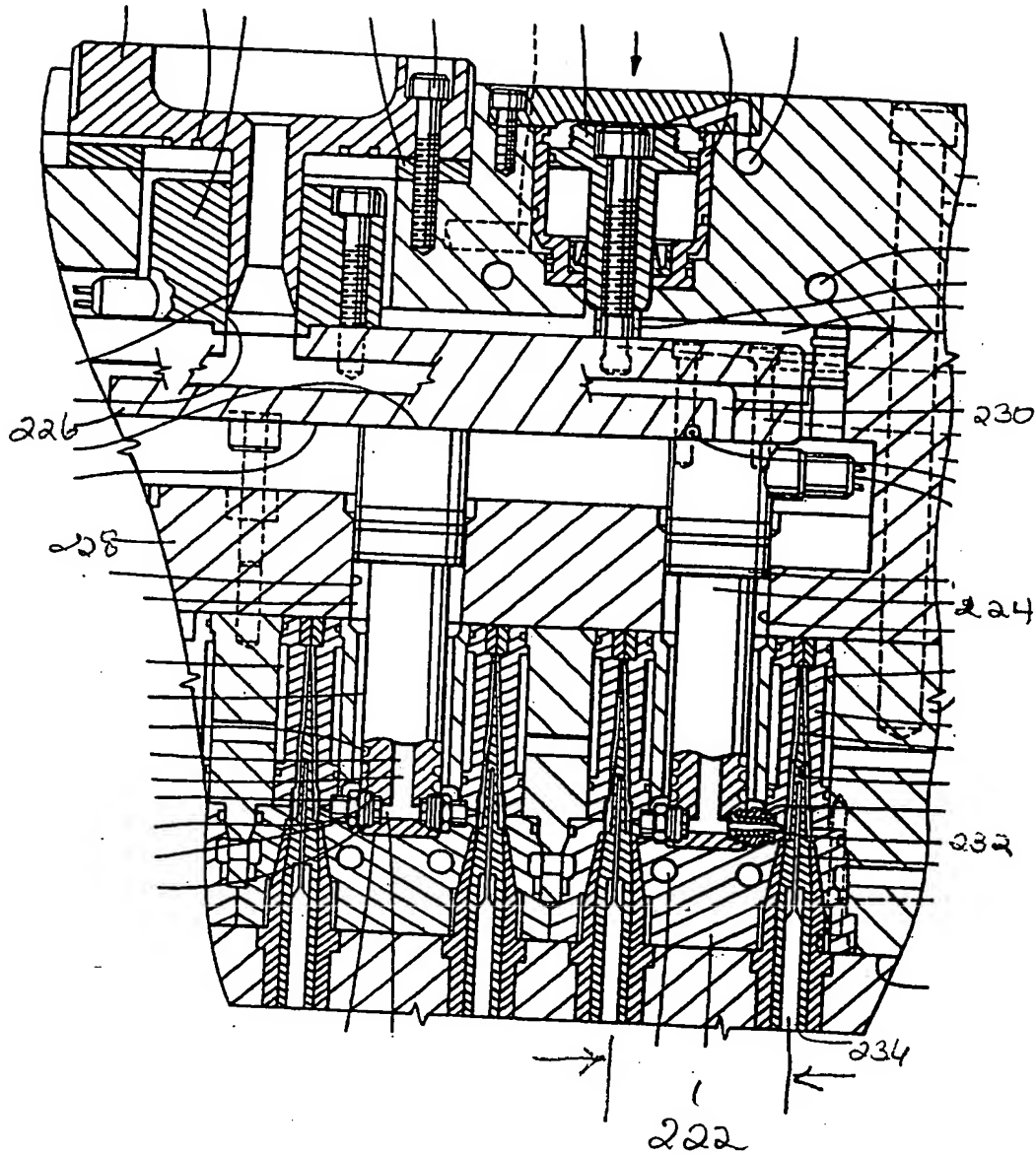


FIG. 12

3240

### System type/Gating method Selection

Click on the number beside the system type to continue. Click on one of the links below to find out more information about the item

[Click Here for more information.](#)

[Previous Step](#)

Match System Type	Gating Method	Suitability	Catalog Page/s
<a href="#">1</a> <u>MIM Speed Dura</u> <u>Hecto-Shot</u> 242	<u>Bi-Metallic C-Valve</u> 244	<u>Recommended</u> 246	<a href="#">View</a> M8.01.05 248

260  
3

# MERLIN Configurator


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M O L D - M A S T E R S

## Gate Seal

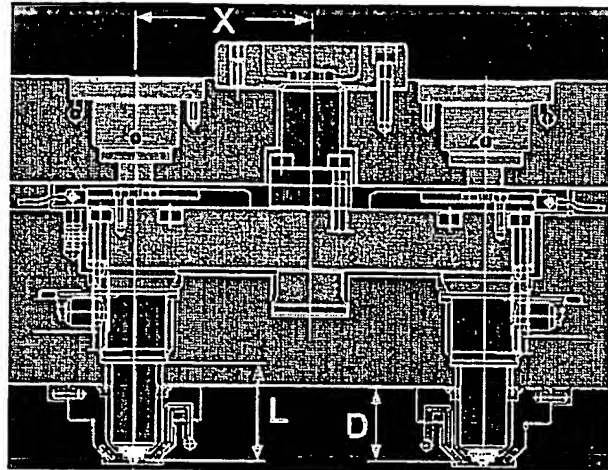
Please select the gate seal you require, or click [HERE](#) for more information.

Previous Step

March Gate Seal #	Description	Diameter/Range
	TS0664P2 MDH C VALVE TS0664 + TSL229	4.0 - 5.0 mm

268

## MIM Dura Hecto-Shot ® Bi-Metallic C-Valve



- 262 Gate Seal
- 264 Nozzle
- 266 Manifold
- Water Cooled Gate Insert
- Valve Actuator
- Inlet Component
- Locating Ring
- Manifold Plates

## Relevant Catalog Pages

Catalog Page Title

[View](#) M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

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## MERLIN Configurator

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Merlin Support

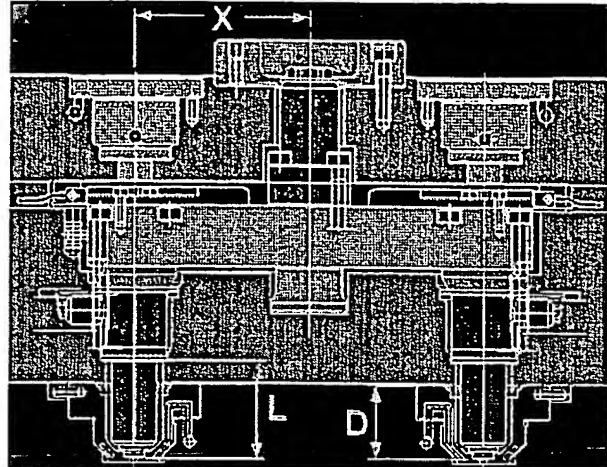
MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

### Nozzle

Please select the nozzle you require, or click [HERE](#) for more information.

Previous Step

### MIM Dura Hecto-Shot ® Bi-Metallic C-Valve



Gate Seal Water Cooled Gate Insert Locating Ring  
Nozzle Valve Actuator Manifold Plates  
Manifold Inlet Component

March	Nozzle #	Description	L Dim (mm)
282	1	NZMH1B1A060P Mim Dura Hecto Valve nozzle L=60	74
284	2	NZMH1B1A090P Mim Dura Hecto Valve nozzle L=90	104
286	3	NZMH1B1A120P Mim Dura Hecto Valve nozzle L=120	134
288	4	NZMH1B1A150P Mim Dura Hecto Valve nozzle L=150	164

### Relevant Catalog Pages

Catalog Page Title

290	<a href="#">View</a>	M8.01.05 MDH C VALVE TS0664 + TSL229
	<a href="#">View</a>	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

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### CAD Drawings

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300

## Number Of Nozzles Selection

Please select the number of nozzles required for your system, or Click [HERE](#) for more information

Previous Step

Enter Number of Nozzles/Drops desired in System

- 302 ☒ 2 Nozzles
- 304 ☒ 4 Nozzles

### Relevant Catalog Pages

Catalog Page Title

Revision Date

CAD Drawings

<a href="#">View</a>	M8.01.05 Mim Dura Hecto Valve nozzle L=120
<a href="#">View</a>	M8.01.05 MDH C VALVE TS0664 + TSL229
<a href="#">View</a>	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

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300

320

## Manifold Configuration Selection

Please choose a suitable manifold configuration from the icons shown below or click [HERE](#) for more detailed information.

Previous Step

### Standard Sub Manifolds



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### Relevant Catalog Pages

Catalog Page Title

<a href="#">View</a>	M8.01.05 Mim Dura Hecto Valve nozzle L=120
<a href="#">View</a>	M8.01.05 MDH C VALVE TS0664 + TSL229
<a href="#">View</a>	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

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## MERLIN<sup>®</sup> Configurator

Merlin<sup>®</sup> Home Merlin<sup>®</sup> Support

M O I L D - M A S T E R S

### Sub Manifold Pitch Selection

Click [Here](#) for more detailed information

[Previous Step](#)

Click the [Next](#) button to accept this dimension or enter a smaller pitch dimension for your application if required.

Off Pitch X: 190 mm

[Next](#)

342

#### Relevant Catalog Pages

Catalog Page Title

Revision Date

CAD Drawings

<a href="#">View</a>	M8.01.05 Mim Dura Hecto Valve nozzle L=120
<a href="#">View</a>	M8.01.05 MDH C VALVE TS0664 + TSL229
<a href="#">View</a>	M8.01.05 MIM Dura Hecto-Shot <sup>®</sup> Bi-Metallic C-Valve

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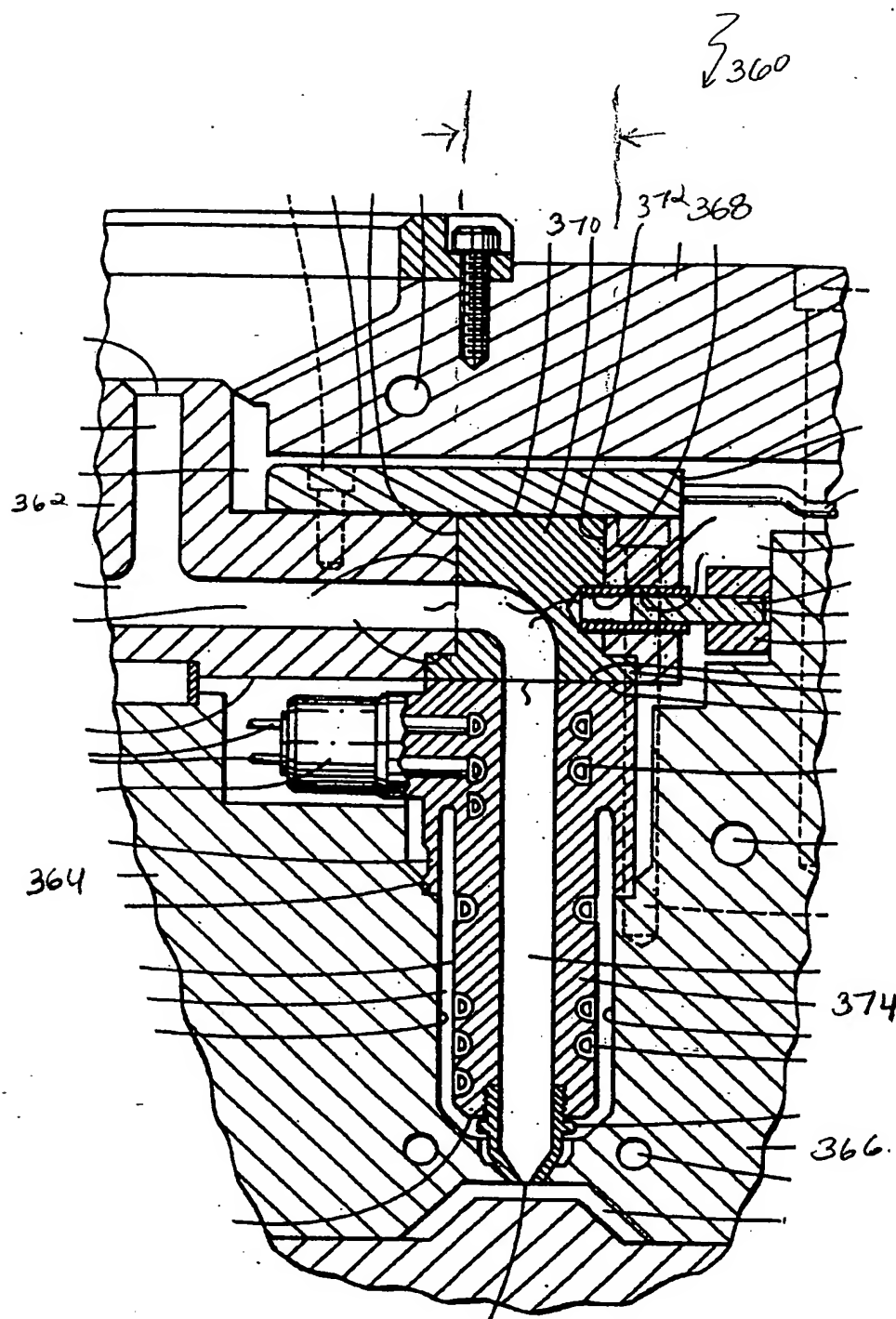
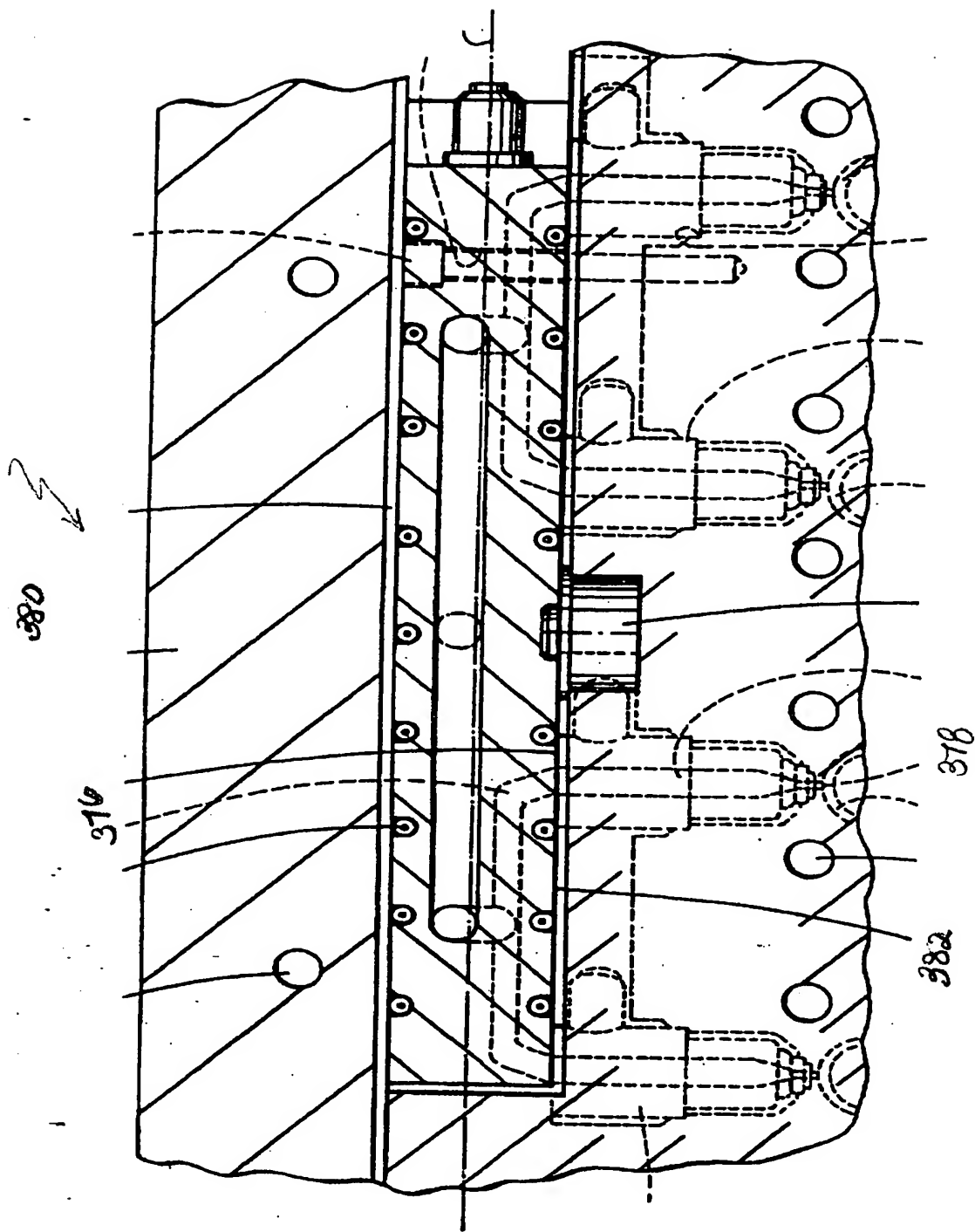


FIG. 19



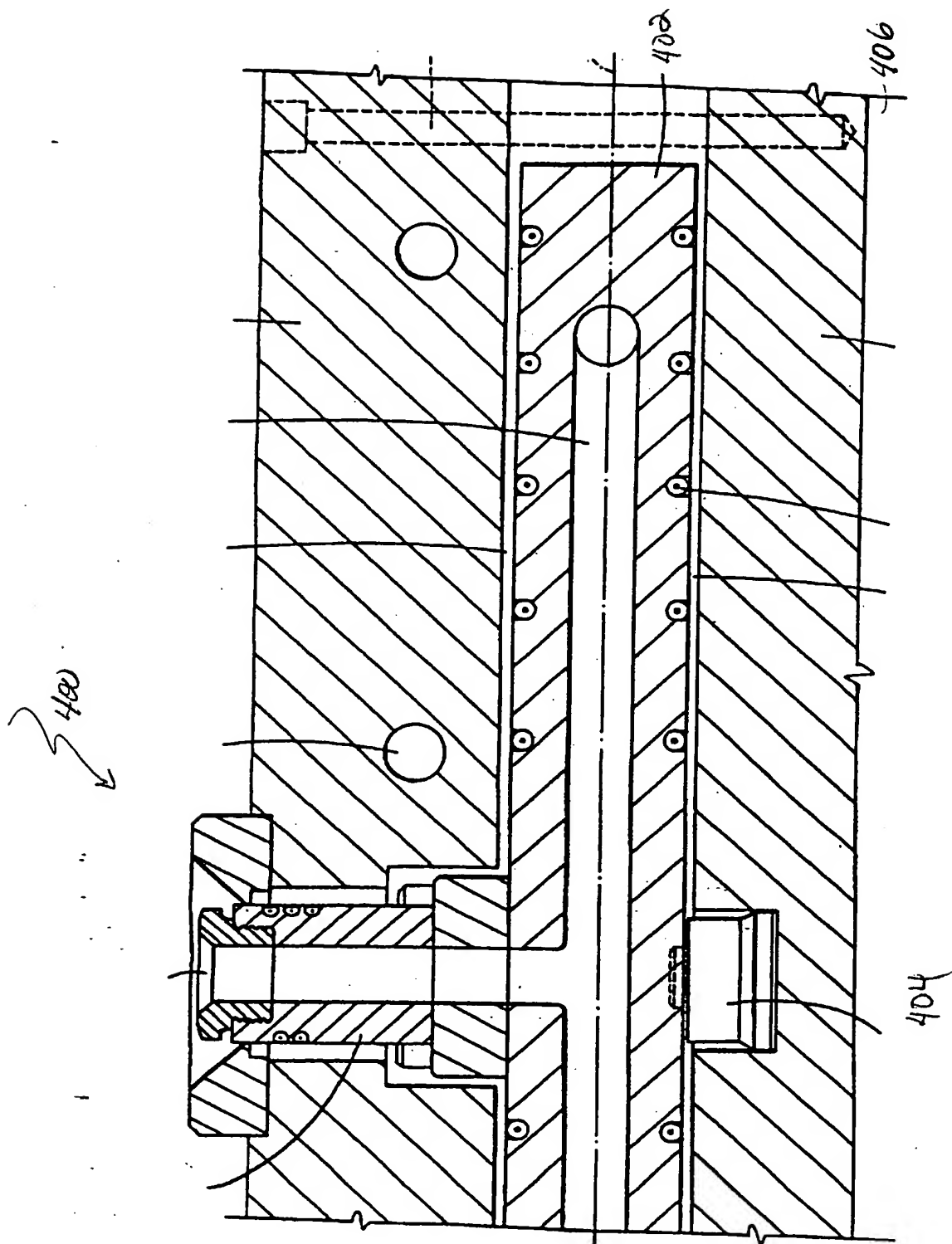


FIG. 21

420

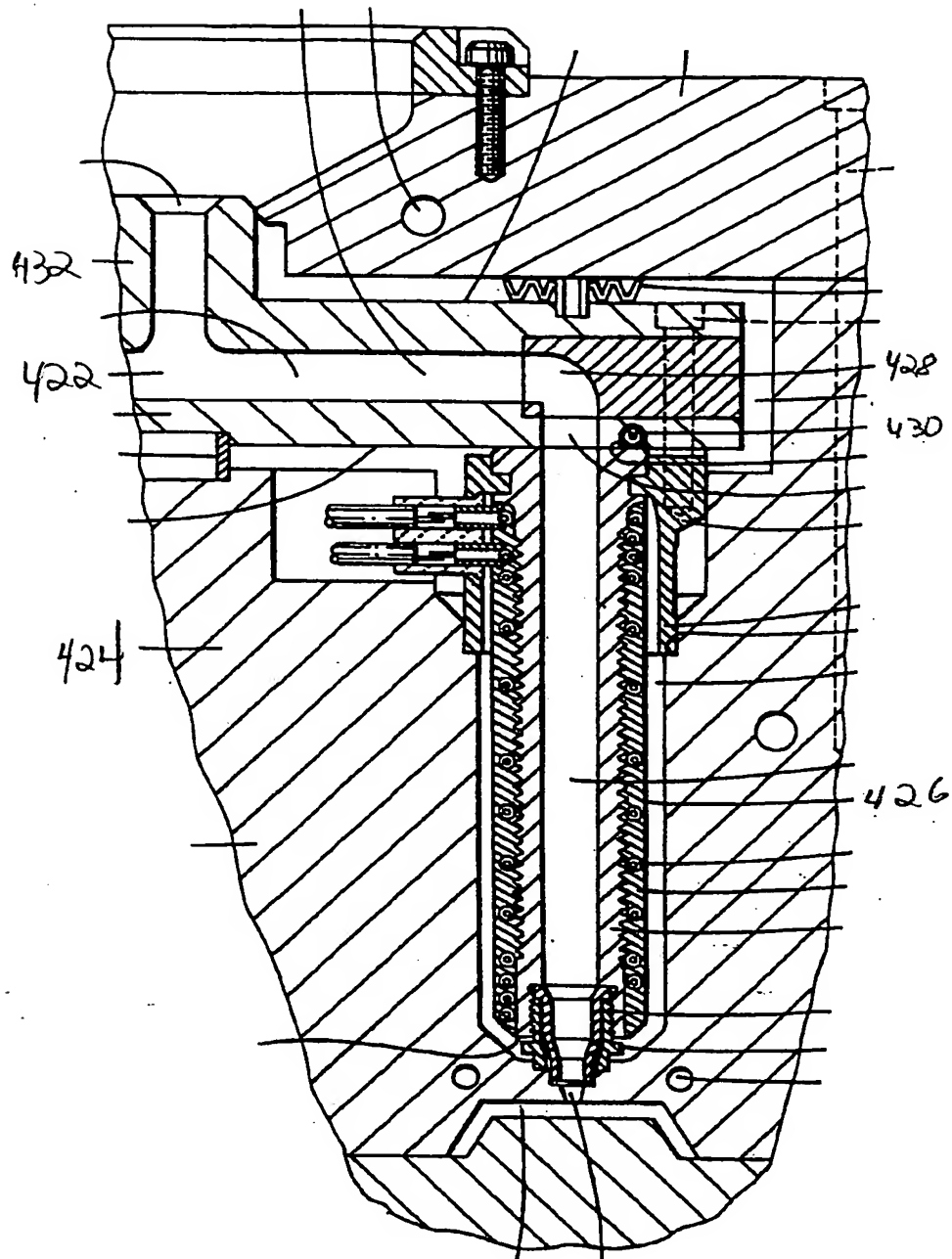


FIG. 22

3440

### Water Cooled Gate Insert (Optional)

Please select the gate insert you require, or click [HERE](#) for more information.

Previous Step

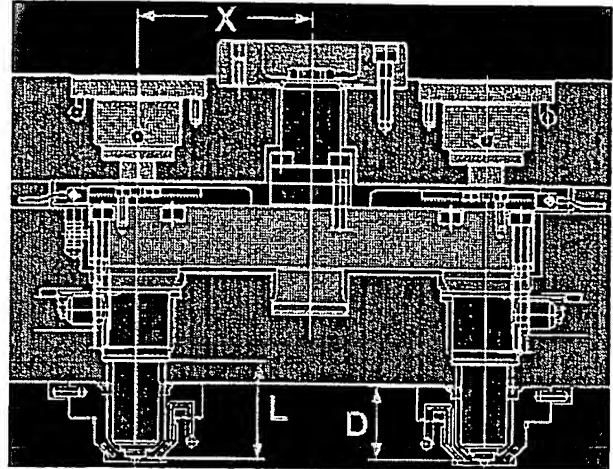
Match Gate Insert #	Description
---------------------	-------------

Water Cooled Gate Inserts are not available for this application.

O  
Dimension

NEXT

### MIM Dura Hecto-Shot ® Bi-Metallic C-Valve



<input checked="" type="checkbox"/> Gate Seal	<input checked="" type="checkbox"/> Water Cooled Gate Insert	<input checked="" type="checkbox"/> Locating Ring
<input checked="" type="checkbox"/> Nozzle	<input checked="" type="checkbox"/> Valve Actuator	<input checked="" type="checkbox"/> Manifold Plates
<input checked="" type="checkbox"/> Manifold	<input checked="" type="checkbox"/> Inlet Component	

442

### Relevant Catalog Pages

Catalog Page Title

Revision Date

CAD Drawings

<a href="#">View</a>	M8.02.02 2-Inline Sub Manifold
<a href="#">View</a>	M8.01.05 Mim Dura Hecto Valve nozzle L=120
<a href="#">View</a>	M8.01.05 MDH C VALVE TS0664 + TSL229
<a href="#">View</a>	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

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## MERLIN Configurator

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### Valve Actuator

Please select the valve actuator you require, or click [HERE](#) for more information.





Previous Step

Match Valve Actuator #	Description	Valve Pin Max. Length	Valve Pin Diameter	Valve Pin Stroke
 HY6600D	Hydraulic/Pneumatic Cylinder Assembly	355.0 mm	7.940 mm	20.0 mm

464

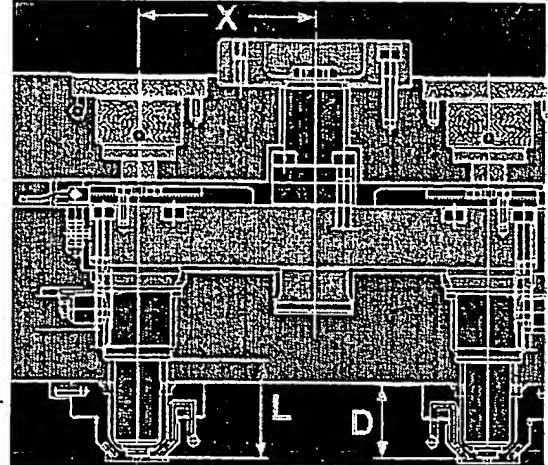
#### Relevant Catalog Pages

Catalog Page Title

 View	M8.02.02 2-Inline Sub Manifold
 View	M8.01.05 Mim Dura Hecto Valve nozzle L=120
 View	M8.01.05 MDH C VALVE TS0664 + TSL229
 View	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

466

### MIM Dura Hecto-Shot ® Bi-Metallic C-V



Gate Seal Water Cooled Gate Insert Locating Manifold  
Nozzle Valve Actuator Inlet Component

462

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## MERLIN Configurator

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M O D E L M A S T E R S

### Inlet Component

Please select the Inlet Component you require, or click [HERE](#) for more information.

[Previous Step](#)

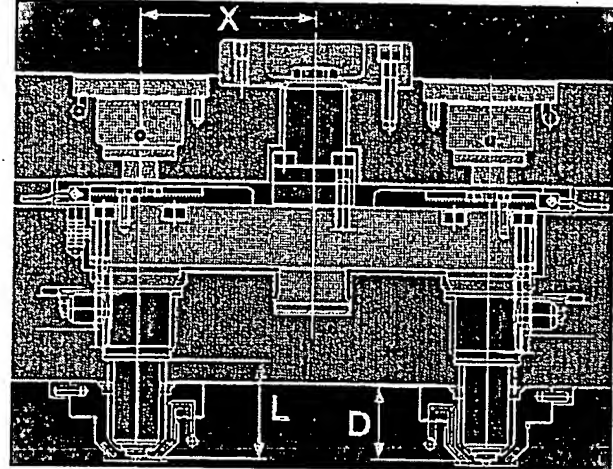
#### Matches Description



Manifold center heater

484

### MIM Dura Hecto-Shot ® Bi-Metallic C-Valve



☐ Gate Seal ☐ Water Cooled Gate Insert ☐ Locating Ring  
☐ Nozzle ☐ Valve Actuator ☐ Manifold Plates  
☐ Manifold ☐ Inlet Component

482

### Relevant Catalog Pages

Catalog Page Title

Revision Date

CAD Drawings

<a href="#">View</a>	12.01.12 Hydraulic/Pneumatic Cylinder Assembly
<a href="#">View</a>	M8.02.02 2-Inline Sub Manifold
<a href="#">View</a>	M8.01.05 Mim Dura Hecto Valve nozzle L=120
<a href="#">View</a>	M8.01.05 MDH C VALVE TS0664 + TSL229
<a href="#">View</a>	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve

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500

### Inlet Component Manifold center heater

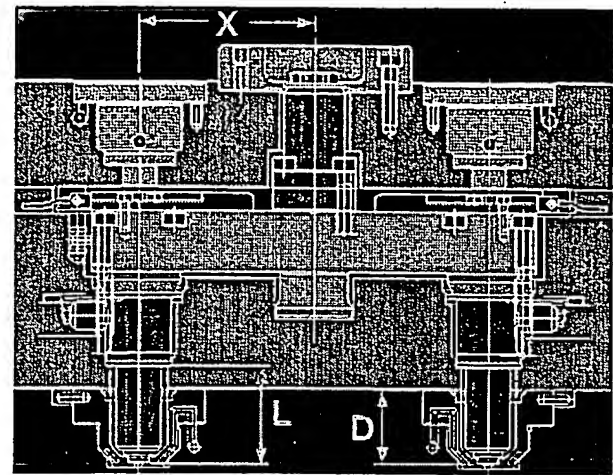
Please select the Inlet Component you require, or click [HERE](#) for more information.

[Previous Step](#)

Matches Inlet Component #	Machine Nozzle Radius
 BP58.500P	0.5 inch
 BP58.750P	0.75 inch

502

### MIM Dura Hecto-Shot ® Bi-Metallic C-Valve













-  Gate Seal
-  Water Cooled Gate Insert
-  Locating Ring
-  Nozzle
-  Valve Actuator
-  Manifold Plates
-  Manifold
-  Inlet Component

### Relevant Catalog Pages

Catalog Page Title

Revision Date

CAD Drawings

 12.01.12 Hydraulic/Pneumatic Cylinder Assembly	98-Oct-22	 506
 M8.02.02 2-Inline Sub Manifold	Jun.	
 M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41AM	
 M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41AM	
 M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve	Jun 6 2000 12:41AM	

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# MERLIN Configurator

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M O L D E R M A S T E R S

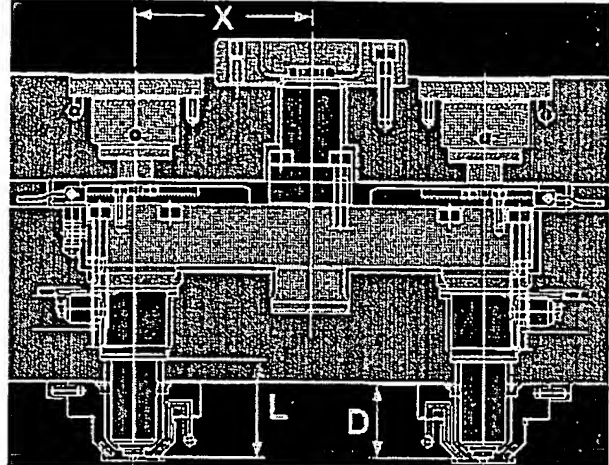
## Location Ring

Please select the locating ring you require, or click [HERE](#) for more information.

Previous Step

Matches	Locating Ring #	Description	Diameter (mm)
524	1	LR0070 Loc. ring for machine nozzle pad	101.34
	2	LR0071 Loc. ring for machine nozzle pad	109.75
	3	LR0081 Locating Ring for Valve system with BP58, inch	101.36
	4	LR0082 Locating Ring for Valve system with BP58, metric	109.77
	5	LR0086 Locating Ring for Sprue system with BP58, inch	101.36
	6	LR0087 Locating Ring for Sprue system with BP58, metric	109.77

## MIM Dura Hecto-Shot® Bi-Metallic C-Valve



- Gate Seal
- Nozzle
- Manifold
- Water Cooled Gate Insert
- Valve Actuator
- Inlet Component
- Locating Ring
- Manifold Plates

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## Relevant Catalog Pages

Catalog Page Title

Revision Date

CAD Drawings

<a href="#">View</a>	10.01.11	Manifold center heater
<a href="#">View</a>	12.01.12	Hydraulic/Pneumatic Cylinder Assembly
<a href="#">View</a>	M8.02.02	2-Inline Sub Manifold
<a href="#">View</a>	M8.01.05	Mim Dura Hecto Valve nozzle L=120
<a href="#">View</a>	M8.01.05	MDH C VALVE TS0664 + TSL229
<a href="#">View</a>	M8.01.05	MIM Dura Hecto-Shot® Bi-Metallic C-Valve

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# MERLIN Configurator

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MIM Dura Hecto Shot Bi-Metallic C-Valve

## Molding Elevation

If you wish to include a Molding Elevation, please enter it below and choose the Unit of Measure.

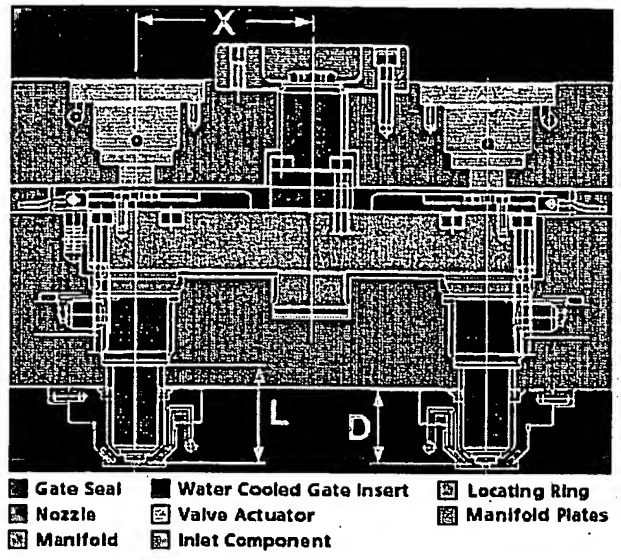
Click [HERE](#) for more information.

Previous Step

There is no Molding Elevation range available for this application. Click Next to continue or try another application.

Next

## MIM Dura Hecto-Shot ® Bi-Metallic C-Valve



## Relevant Catalog Pages

Catalog Page	Title	Revision Date	CAD Drawings
<a href="#">View</a>	M9.01.08 Locating Ring for Valve system with BP58, inch	Jun 6 2000 12:41AM	<a href="#">Download</a>
<a href="#">View</a>	10.01.11 Manifold center heater	98-Oct-22	<a href="#">Download</a>
<a href="#">View</a>	12.01.12 Hydraulic/Pneumatic Cylinder Assembly	98-Oct-22	<a href="#">Download</a>
<a href="#">View</a>	M8.02.02 2-Inline Sub Manifold	Jun	<a href="#">Download</a>
<a href="#">View</a>	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41AM	<a href="#">Download</a>
<a href="#">View</a>	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41AM	<a href="#">Download</a>
<a href="#">View</a>	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve	Jun 6 2000 12:41AM	<a href="#">Download</a>

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**MERLIN Configurator**

M O L D M A S T E R S

Merlin Home Merlin Support

## Application Information Form

Please fill in the relevant information and check for correctness.

Previous Step

Action To Be Taken, For more information click [HERE](#)

Company Name:

Contact Name

Mold Maker

Molder

End User

Customer Ref. #

Requested Delivery Date (in MM/DD/YYYY format)

Plastic Part #

Plastic Part Name

Industry Segment

### Additional Information

Material

Part

Mold

Other

Material type :

Shot Weight :

# of Cavities

Gate Cosmetics

Acrylonitrile Butadiene Sty.

500 - 3500 g

Grade

Est. Injection Time (sec.)

564 Sub-runners

Gate Cooling

566

Supplier

Wall Thickness

Gate

Dim. Stability

mm

mm

Process Temp

Flow Length

Land

Supp. Screws

C

mm

mm

## Summary Information Form

Please fill in the relevant information and check for correctness.

[Previous Step](#)

[View Printable Version](#)

Action To Be Taken, For more information click [HERE](#)

Step 1

Save

582

Step 2

Quote

584

Step 3

Review

586

Step 4

Order

588

Lead Time: No Lead Time Available.

Quote #: 0040003107

Order #:

[Generate Drawings](#)

Price: \$6,081.00 USD

Not Reviewed.

PO#

N/A

Company Name:

590

Contact Name:

Mold Maker:

Molder:

End User:

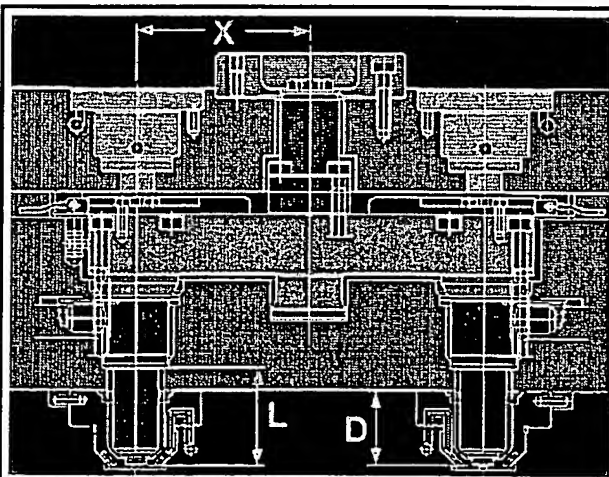
Customer Ref. #:

Requested Delivery Date:

Plastic Part #:

Plastic Part Name:

Industry Segment:



### Required Parts List

Part Number	Description	Options
TS0664P2	MDH C VALVE TS0664 + TSL229	N/A
NZMH1B1A120P	Mim Dura Hecto Valve nozzle L=120	N/A
MNMDH2I200BL4VP	2-Inline Sub Manifold	N/A
HY6600D	Hydraulic/Pneumatic Cylinder Assembly	N/A
BP58.750P	Manifold center heater	N/A
LR0081	Locating Ring for Valve system with BP58, inch	N/A

### Additional Information

Material

Part

Mold

Other

Material type:

Acrylonitrile Butadiene Styr.

Sh t Weight: 500 - 3500 g

# of Cavities:

Gate Cosmetics:

Grade:

Est. Injecti n Time (sec.):

Sub-runners:

Gate Cooling:

Supplier:

Wall Thickness:

Gate:

Dim. Stability:

3600 -

## Generated Drawings

Choose any of the file options below to download or view online

Type	Drawings	Options
TIF	<u>GT_sys_valve_config HY6600_0077.tif</u> (1449539 Bytes)	<a href="#">Download</a> <span>602</span> <a href="#">View</a> <span>604</span>
TIF	<u>GT_sys_valve_config SYSTEM ASSEMBLY.tif</u> (1170968 Bytes)	<a href="#">Download</a> <a href="#">View</a>
DXF	<u>GT_sys_valve_config HY6600_0077.dxf</u> (1095118 Bytes)	<a href="#">Download</a> <a href="#">View</a>
DXF	<u>GT_sys_valve_config SYSTEM ASSEMBLY.dxf</u> (1786603 Bytes)	<a href="#">Download</a> <a href="#">View</a>
IGS	<u>GT_sys_valve_config HY6600_0077.igs</u> (2487962 Bytes)	<a href="#">Download</a> <a href="#">View</a>
IGS	<u>GT_sys_valve_config SYSTEM ASSEMBLY.igs</u> (2302724 Bytes)	<a href="#">Download</a> <a href="#">View</a>
WRL	<u>GeneralAssembly.wrl</u> (2461551 Bytes)	<a href="#">Download</a> <a href="#">View</a>

FIG. 31



6220

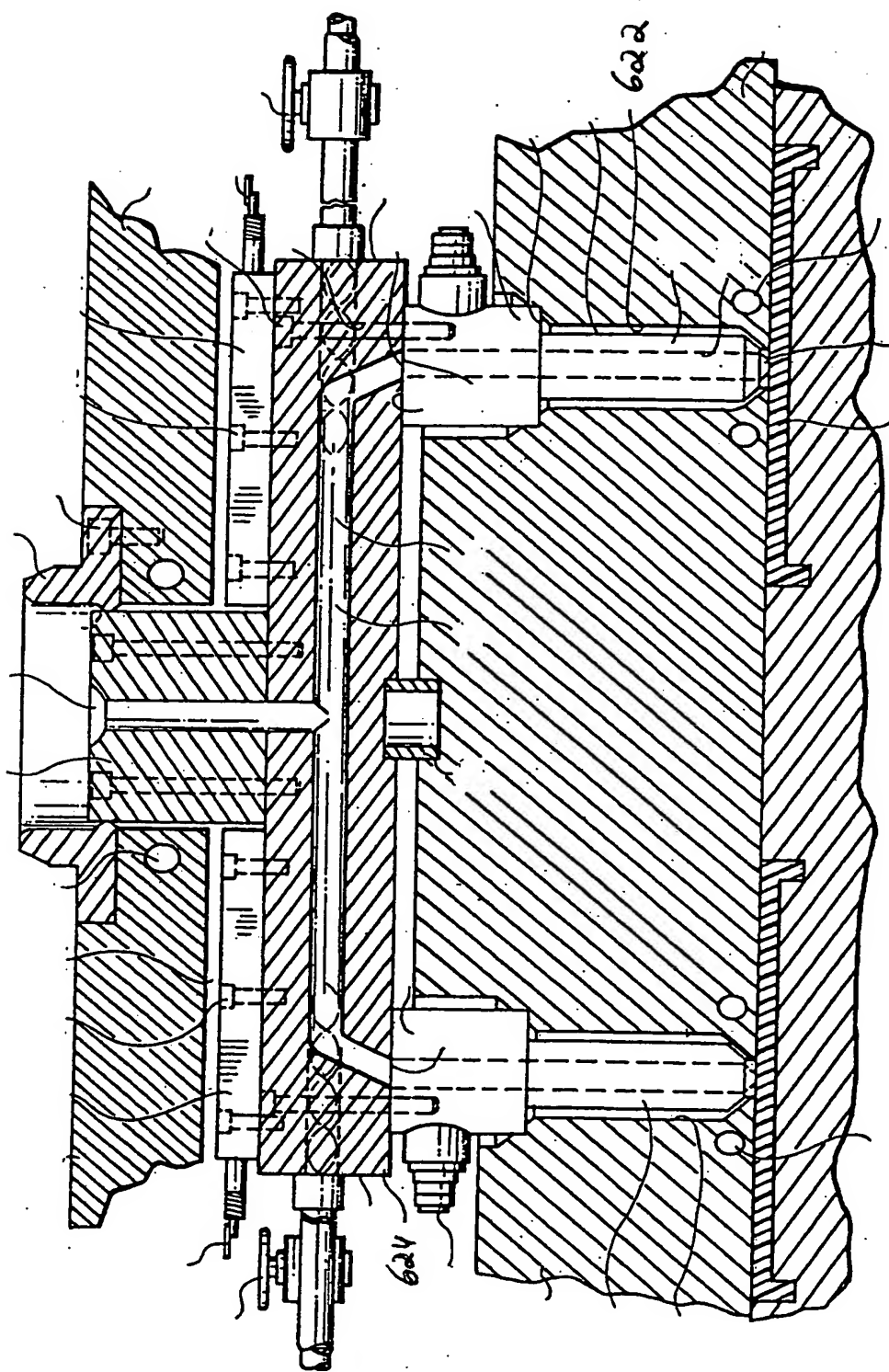


FIG. 32

640

# Configurator

Please make a selection. For detailed information concerning your possible choices click [here](#).

Action	Description
Configure New System	Allows you to configure a new system and save it to your account.
Existing Configurations	Allows you to load an existing system from a list of saved systems.

124

3 660

# MERLIN Configurator

Merlin Home Merlin Support

M O L D S M A S T E R S

## Existing Configurations

Please Make a selection. For detailed information concerning your possible choices click [HERE](#)

Action			Configuration Name	Quote #	Order #	Date/Time	Status
Load	Copy	Delete	Preview Mongas Config 662	0040003107		6/12/00 2:39:47 PM	
Load	Copy	Delete	SAP Test	0040003098		6/9/00 11:31:20 AM	
Load	Copy	Delete	2 drop hect 190 pitch	0040003093		6/8/00 1:53:36 PM	

666

664

680

# MERLIN Configurator

Merlin Home Merlin Support

M O L D - A M L A S T E R S

## Summary Information Form

Please fill in the relevant information and check for correctness.

Previous Step

View Printable Version

Action To Be Taken, For more information click [HERE](#)

Step 1

Save

682

Step 2

Quote

684

Step 3

Review

686

Step 4

Order

688

Lead Time: No Lead Time Available.

Quote #: 0040003107

Order #:

Generate Drawings

Price: \$6,681.00 USD

Not Reviewed.

PO #

N/A

Company Name:

610

Contact Name:

Mold Maker:

Molder:

End User:

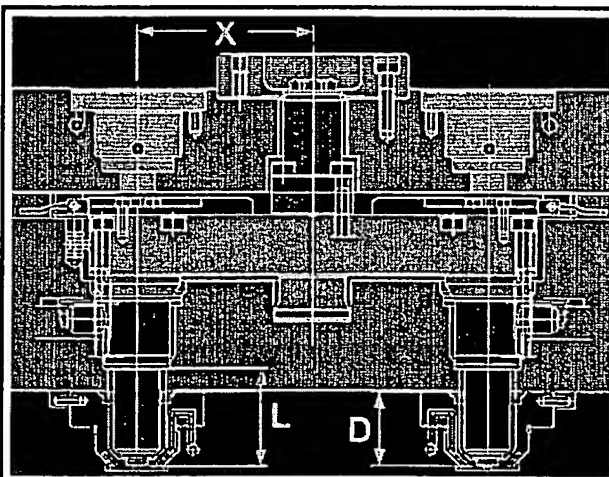
Customer Ref. # :

Requested Delivery Date:

Plastic Part # :

Plastic Part Name:

Industry Segment :



### Required Parts List

Part Number	Description	Options
TS0664P2	MDH C VALVE TS0664 + TSL229	N/A
NZMH1B1A120P	Mim Dura Hecto Valve nozzle L=120	N/A
MNMDH21200BL4VP	2-Inline Sub Manifold	N/A
HY6600D	Hydraulic/Pneumatic Cylinder Assembly	N/A
BP58.750P	Manifold center heater	N/A
LR0081	Locating Ring for Valve system with BP58, inch	N/A

### Additional Information

Material

Part

Mold

Other

Material type :  
Acrylonitrile Butadiene  
Styr.

Shot Weight : 500 -  
3500 g

# of Cavities :

Gate Cosmetics:

Grade:

Est. Injection Time  
(sec.):

Sub-runners:

Gate Cooling:

Supplier:

Wall Thickness:

Gate:

Dim. Stability: